

Date:
User:Thursday, 11/9/2006 4:32:02 PM
Kim Johnston

Process Sheet

Split
SB 06/11/29

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AVIONICS RISER CONSOLE
 Job Number : 29376
 Estimate Number : 10259
 P.O. Number : N/A Part Number : D212722011
 This Issue : 11/9/2006 S.O. No. : N/A Drawing Number : D3363 REV B 1 06.11.10 RH
 Prsht Rev. : NC Project Number : N/A 06.11.10
 First issue : N/A Type : SMALL /MED FAB Drawing Revision : B 1
 Previous Run : 23334 Material : N/A
 Due Date : 12/15/2006 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : 06 11 10
 Comment : Est Rev:B 05.04.11 Now made at Dart KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D212-722-011 CHG002

KT 06-11-13 (4)

2.0 M6063T5A0750W063 Angle6063T5X.75X.75X.063



Comment: Qty.: 7.2450 f(s)/Unit Total: 28.9800 f(s)

Material: 6063-T52 Aluminum angle 3/4" x 3/4" x 0.063" wall(M6063T5A0.750W.063)

Batch: 119681 x (16)

M102741 x (8)

FF 06-11-23

3.0 M6063T5C75X75W125 6063 CHANNEL.75X.75X.125



Comment: Qty.: 0.8290 f(s)/Unit Total: 3.3160 f(s)

Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall(M6063T5C.75x.75W.125)]

Batch: M17695

FF 06-11-23

4.0 D33631 CONSOLE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3363-1 Console (Bent)

B29402

SB 06/11/23 (4)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1




Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut (2) D3360-1, (2) D3360-3 & (2) D3360-5 to length as per Dwg D3360Material: 6063-T52 Aluminum
angle 3/4" x 3/4" x 0.063" wall

FF 06-11-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/11/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/24	5	1 part scrap was cut to short (D3360-S)		Scrap & replace	FF 06-11-24	MS 06/11/24	MS 06/11/24	MS 06/11/24
06/11/29	5	C'sink holes were oversunk (See attached)	FF per 255042 06.11.29	plug affixed holes with weld, re-drill and c'sink see DS e-mail attached	pit 06.11.29			MS 06/11/30

NOTE: Date & initial all entries

Date: Thursday, 11/9/2006 4:32:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AVIONICS RISER CONSOLE

Job Number: 29376

Part Number: D212722011

Job Number:



Seq. #:

Machine Or Operation:

Description:

2-Cut (1) D3361-1 to length as per Dwg D3361 Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall

3-Deburr D3360-1/-3/-5 & D3361-1

4-Transfer drill and C'Sink D3360-1/-3/-5 & D3361-1 from D3363-1 as per D3363. Do not rivet together

5-Deburr all parts

FF 06-11-23 4

FF 06-11-29 4

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06-11-29 4

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SD 06/11/29 (4)

8.0

PR351

DZUS FASTENER RAIL



Comment: Qty.: 0.6666 f(s)/Unit Total: 2.6664 f(s)

Material: Dzus Fastener Rail

(PR35-1 or PR3-1/2-1)

Batch: M 17763(x5) M 17091(x3)

FF 06-11-30 4

9.0

MS20426AD45

Rivet



Comment: Qty.: 44.0000 Each(s)/Unit Total: 176.0000 Each(s)

Pick:

Qty Part Number

Description Batch

44 MS20426AD4-5

Rivet M 4067

FF 06-11-30 4

10.0

MS20426AD46

Rivet



Comment: Qty.: 9.0000 Each(s)/Unit Total: 36.0000 Each(s)

Pick:

Qty Part Number

Description Batch

9 MS20426AD4-6

Rivet M 100151

FF 06-11-30 4

11.0

D33621

DZUS RAIL



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 d3362-1 Dzus Rail

329376
M 17763(x5) / M 17091(x3) FF 06-11-23 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/9/2006 4:32:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AVIONICS RISER CONSOLE

Job Number: 29376

Part Number: D212722011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut (2) D3362-1 to length as per Dwg D3362 Material: Dzus Fastener Rail

2-Rivet D3360-1/-3/-5 & D3361-1 as per Dwg D3363

Identify as D3363-041

D3362-1

FF 06-11-30

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

NOV 06/11/30 (4)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

15.0

PFSC3538A

Dzus 1/4 turn fastener



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 PFSC35-38A

Dzus Fastener

M19567

1 d3363-041

Console Ass

B29376

06/11/30 (4)

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

11/9/11/30 (4)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D212-722-011

Rev C 06/11/30 (4)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/01

Job Completion



11/12/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

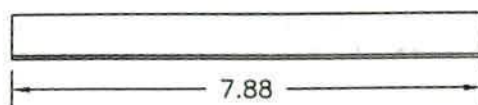
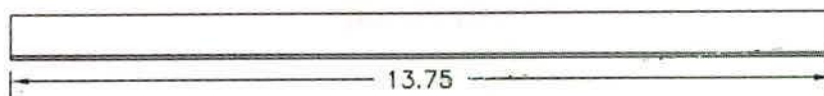
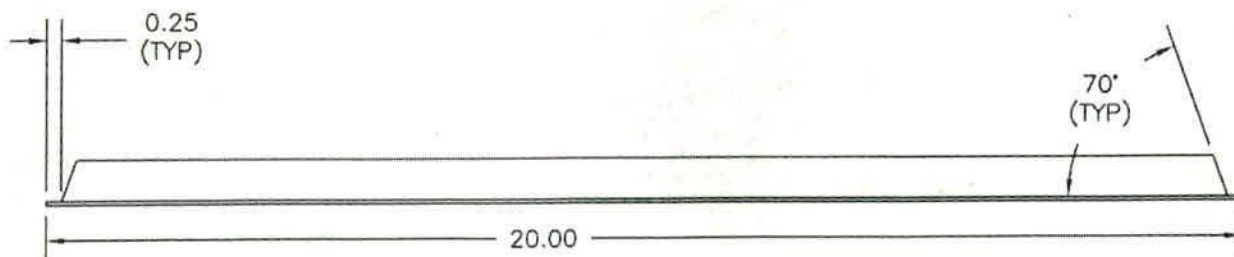
NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3360	REV. A SHEET 1 OF 1
DATE 04.11.29		TITLE ANGLE	SCALE 1:12
A	04.11.29	NEW ISSUE	

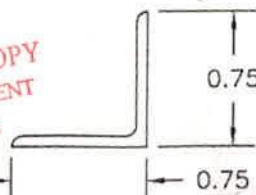
RELEASED

05.03.31

D3360-1
(SCALE 1:3)D3360-3
(SCALE 1:3)D3360-5
(SCALE 1:3)**D3360-1/-3/-5 ANGLE**

- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MATERIAL: 6063-T52 ALUMINUM
STOCK SIZE: 3/4" x 3/4" x 0.063" ANGLE EXTRUSION
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO 29376

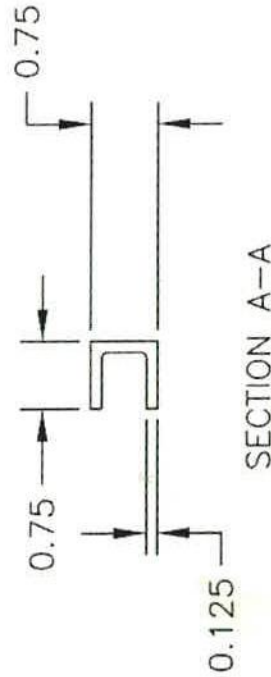
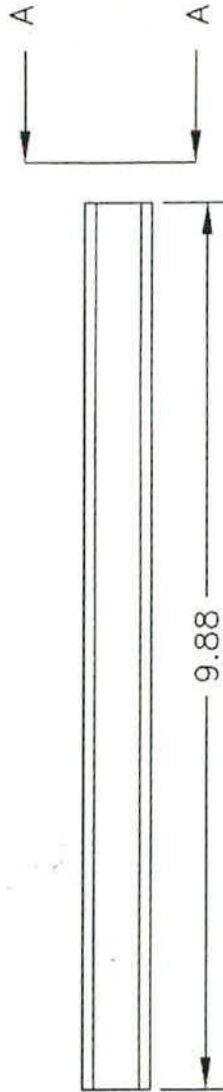
SECTION A-A
(SCALE 1:1)

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CHECKED PH	APPROVED PH	DRAWING NO. D3361	REV. A SHEET 1 OF 1
DATE 04.11.29		TITLE CHANNEL	SCALE 1:2
A	04.11.29	NEW ISSUE	



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D3361-1 CHANNEL

- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MATERIAL: 6063-T52 ALUMINUM
STOCK SIZE: 3/4" x 3/4" x 0.125" CHANNEL EXTRUSION
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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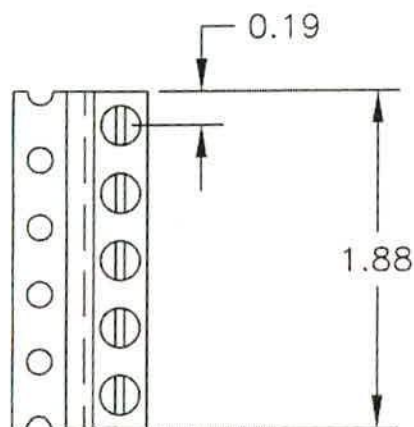
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CHECKED PH	APPROVED PH	DRAWING NO. D3362	REV. A SHEET 1 OF 1
DATE 04.11.29		TITLE RAIL	SCALE 1:1
A	04.11.29	NEW ISSUE	

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05.03.31

D3362-1 RAIL

- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MAKE FROM DZUS RAIL P/N "PR 3-1/2-1" OR PR-35-1
- 3) TOLERANCES ARE PER DART QSI 018
- 4) ALL DIMENSIONS ARE IN INCHES

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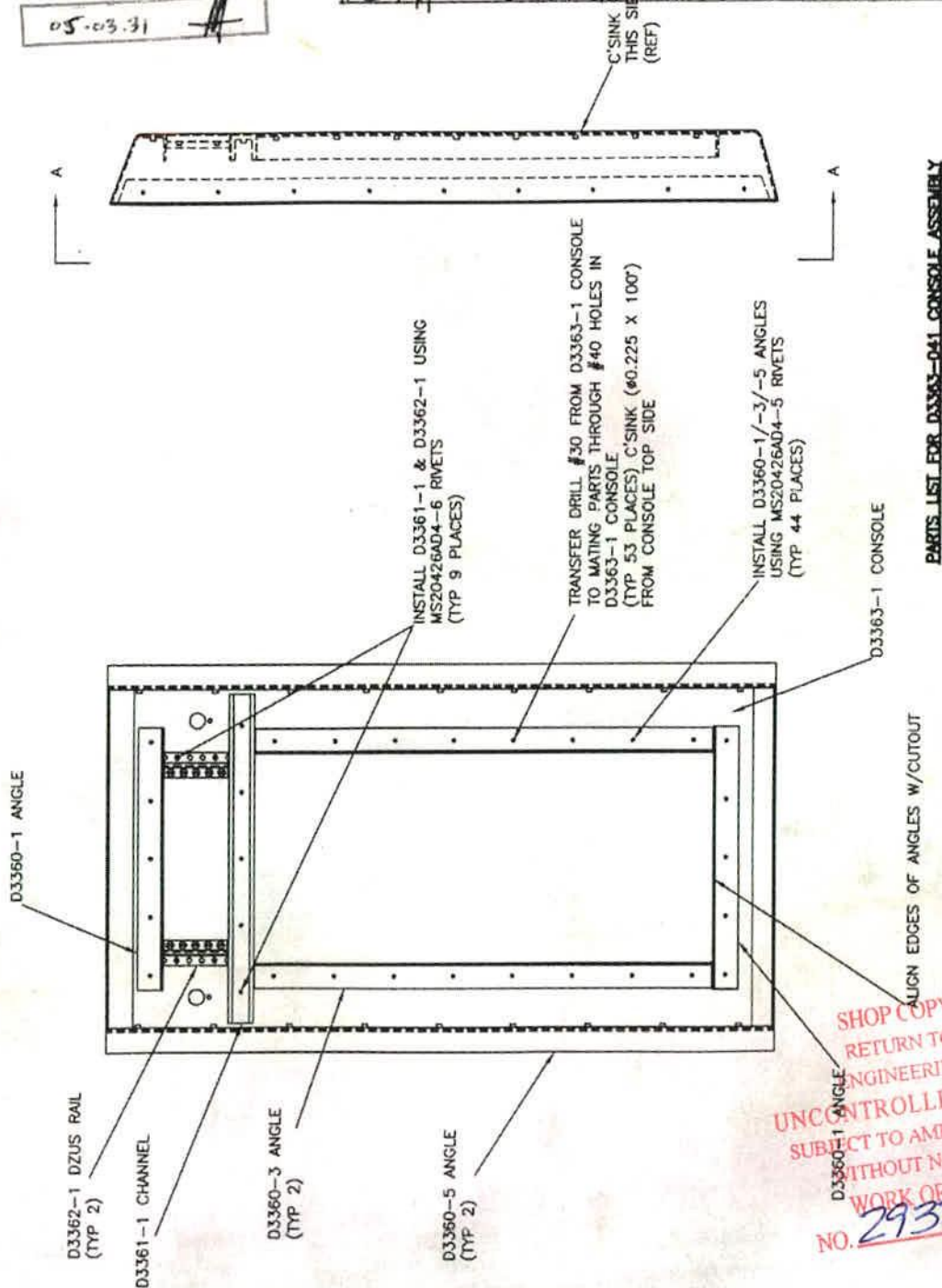
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3363	REV. B SHEET 1 OF 3
DATE 05.03.28		TITLE CONSOLE ASSEMBLY	SCALE 1:5
A	04.11.29	NEW ISSUE	
B	05.03.28	INCREASE WIDTH BY 0.125	
B1	05.04.28	CHANGE WIDTH TO 10.430, WAS 10.43	

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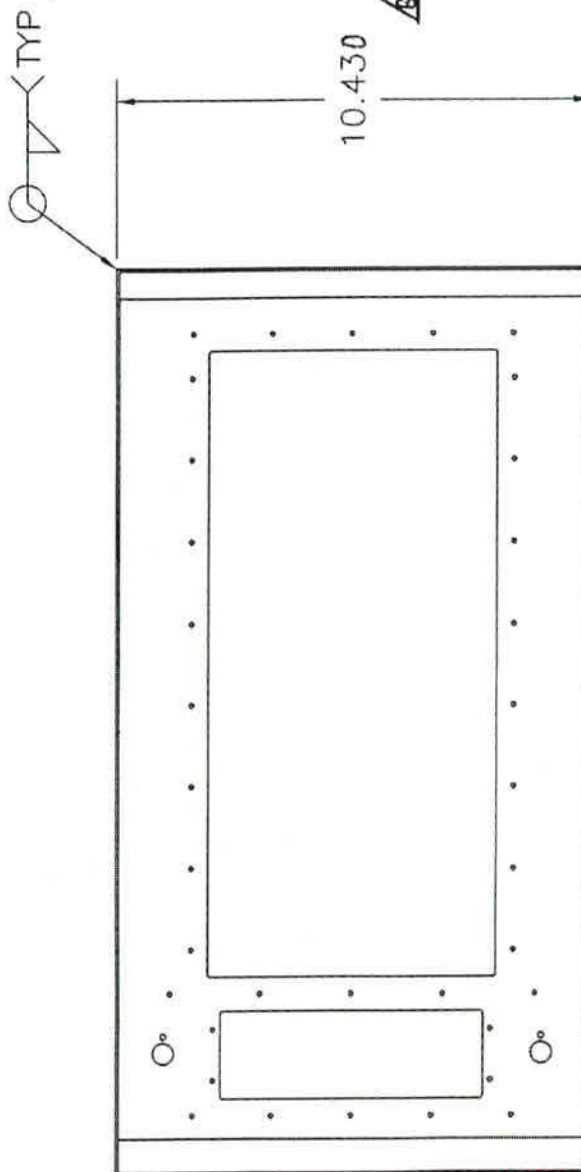
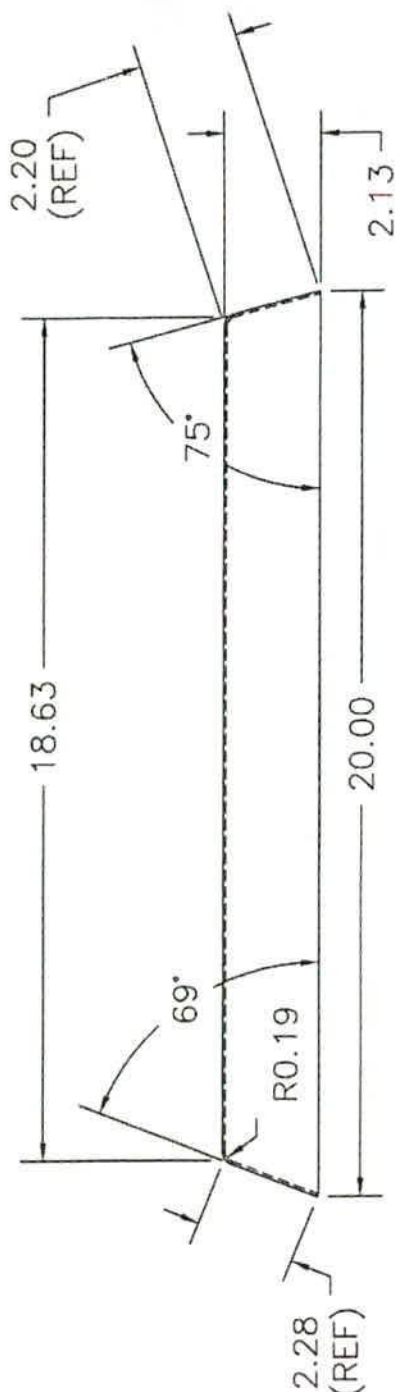
- D3363-041 CONSOLE ASSEMBLY
- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
 - 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
 - 3) FINISH/ACID ETCH AND ALLOINE PER DART QSI 005 4.1

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CHECKED H	APPROVED H	DRAWING NO. D3363	REV. B SHEET 2 OF 3
DATE 05.03.28		TITLE CONSOLE ASSEMBLY	SCALE 1:4

**D3363-1 BEND DETAIL****RELEASED**

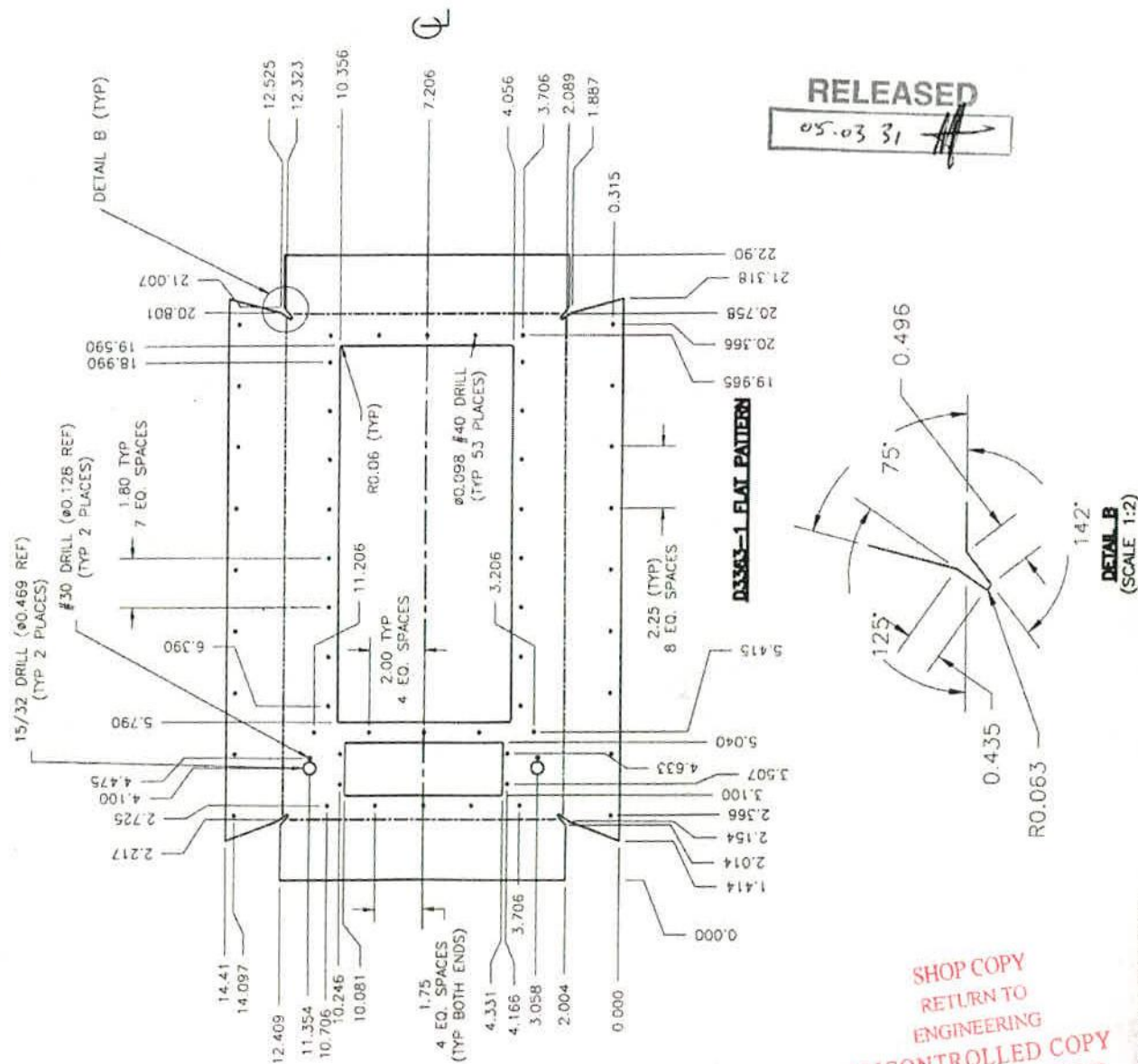
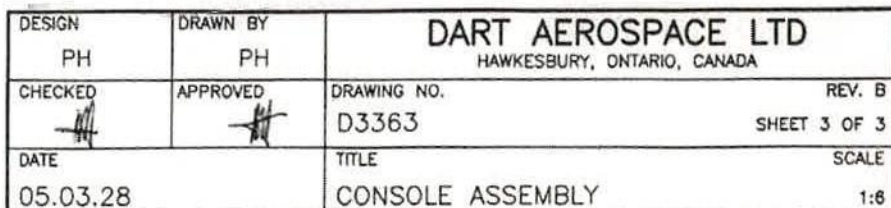
05 03 31

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NO. 29376

- D3363-1 CONSOLE
- 1) WELD PER DART QSI 004
 - 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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D3363-1 CONSOLE (FLAT PATTERN)
1) MATERIAL: 6061-T6/T651 ALUMINUM
2) FINISH: ANOD.
(MATERIAL SPEC: QQ-A-250/11) 0.063 THICK (REF DART SPEC M6061TS.063)
(SCALE 1:2)

D3363-1 CONSOLE (FLAT PATTERN)

1) MATERIAL:	6061 -
2) FINISH:	NONE

2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

5) PART IS SYMMETRICAL ABOUT CENTERLINE

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Peter Hum

From: David Shepherd [dshepherd@dartaero.com]
Sent: November 29, 2006 12:19 PM
To: 'Peter Hum'
Subject: RE: D3363-041 Console oversize rivet holes

It is acceptable to plug these holes with weld and re-drill & countersink.

David

From: Peter Hum [mailto:phum@dartaero.com]
Sent: Wednesday, November 29, 2006 8:36 AM
To: 'David Shepherd'
Subject: D3363-041 Console oversize rivet holes

David,

Production is making the D3363-041 Console for the D212-722. Some of the rivet holes have been over countersunk as shown in the picture. This is on qty (2) D3363-041's. It is over countersunk on a few locations only.

Is it acceptable to fill the hole with weld, grind flush and re-drill the holes?

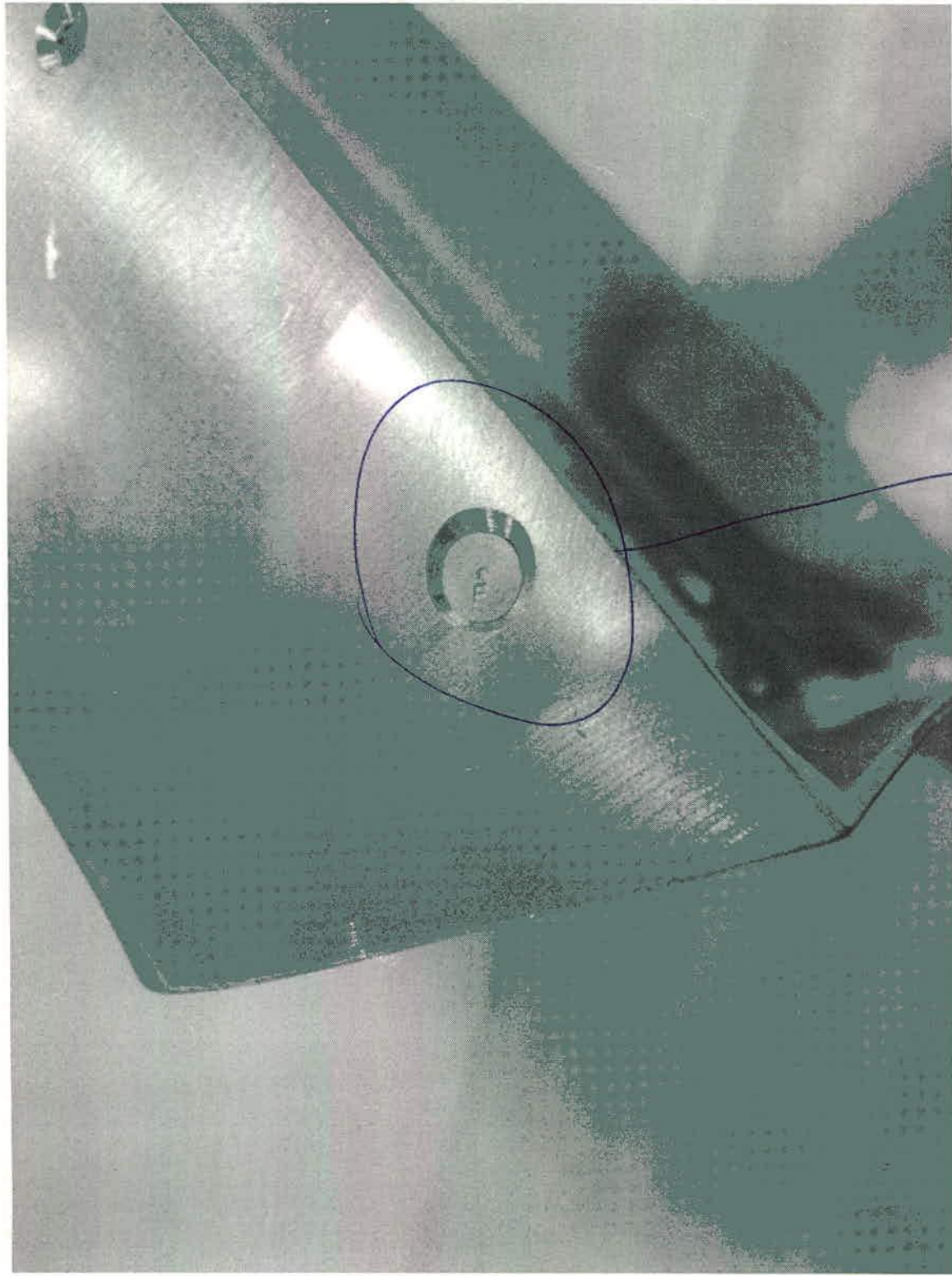
The console is constructed from Aluminum 6061-T6

Peter

--
No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.409 / Virus Database: 268.15.0/557 - Release Date: 11/29/2006

--
No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.1.409 / Virus Database: 268.15.0/557 - Release Date: 11/29/2006

29/11/2006



Over size c'sink

1) weld

2) re-drill

3) c'sink